

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020669**Date Inspected:** 08-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & Tower**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

Trial Assembly

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG);

Segment 12AE, 12BE, 12CE assemblies

Segment 12AW, 12BW, 12CW assemblies

CB19 Crossbeam assembly

CB18 Crossbeam assembly

This QA observed that ZPMC was not performing any work on the above mention components during the time, this QA inspector was present.

Bay 1

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG);

GQ2-F209; 16qty bracket assemblies

10TR1 & 10TR2; 30qty traveler rails

E2-SB12; 3qty steel barrier assemblies

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

Raw Materials (pipe, sq. tube & sq. bar) for Bike Path Hand Rail Assemblies

This QA observed that ZPMC was not performing any work on the above mention components during the time, this QA inspector was present.

Bay 3

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 3, ZPMC was welding on Architectural Housing assembly AH3151. ABF Certified welding Inspector Li Zhi Jiang was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 1 welder performing weld repair and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

AH3151 (WR20208)

Weld-SP3079-001-070

WPS-345-SMAW-3G(3F)-Repair

Welder-058102

3G/SMAW

Bay 4

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG);

11TR3, 11TR1, 10TR1, 11TR2; 30+qty traveler rails

This QA observed that ZPMC was not performing any work on the above mention components during the time, this QA inspector was present.

Bay 6

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG);

CB18, CB19, Floor Beam; 80+qty drilled splice plates

Galvanized Handrails; 80+qty

This QA observed that ZPMC was not performing any work on the above mention components during the time, this QA inspector was present.

Bay 7

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG);

Galvanized Handrails; 80+qty

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

This QA observed that ZPMC was not performing any work on the above mention components during the time, this QA inspector was present.

Bay 8

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG);

BK4A-060; 1qty bike path assembly

BK4A-059; 1qty bike path assembly

BK4A-063; 1qty bike path assembly

BK4A-062; 1qty bike path assembly

This QA observed that ZPMC was not performing any work on the above mention components during the time, this QA inspector was present.

Bay 10

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 10 ZPMC was in process of welding traveler rail weld repair (WR20217). ABF Certified Welding Inspector Yang Yi Heng was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 2 welders performing weld repair and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

WR20217

Weld-20TR2-030-009

WPS-345-SMAW-1G(1F)-Repair

Welder-057258

1G/CJP/SMAW

WR20217

Weld-20TR2-030-013

WPS-345-FCAW-1G(1F)-Repair-1

Welder-040434

1G/CJP/ESAB

During observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG);

BK9A-001; 1qty bike path assembly

BK8A-064; 1qty bike path assembly

Lift 6 North & South Tower Head Assembly

This QA observed that ZPMC was not performing any work on the above mention components during the time, this QA inspector was present.

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

Bay 11

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG);

BK4A-064; 1qty bike path assembly
BK4A-024; 1qty bike path assembly
BK4A-003; 1qty bike path assembly
BK4A-057; 1qty bike path assembly
BK4A-002; 1qty bike path assembly
Lift 6 East & West Tower Head Cover Assembly

This QA observed that ZPMC was not performing any work on the above mention components during the time, this QA inspector was present.

Bay 12

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG);

Segment 14W; 80+qty splice plates

This QA observed that ZPMC was not performing any work on the above mention components during the time, this QA inspector was present.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

“As noted within the contents of this report.”

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
